(9)	
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WORK ORDER	NON-CONFORMAN	NCE / UPDATI

DQA:	Date:		•
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											QA Closed.	Dat	·c· -
Work Ord	ler:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
					<del></del>	Rework	7		Skid-tube	Crosstube	ca.	Water Jet	Engineering
Part	No.					Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	11	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NGR	Νő.					Work Order Update	11		Large Fab	Composite		Supplier	
The state of the s	7	<b>.</b>					_				-		<b>–</b>
Root		3.			Descri	ption of work order update	In	itial	Ac	ction	Sign &		÷*
Cause		Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	cription	Date	Verification	QC Inspector
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Equip/Tooling	$\Box$		}.										
Operator													
Material											i i		
Setup			ĺ										
Other													
Process													
Supplier	П		ļ									·	
Training													
Unapproved	$\Box$												
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Landi	ing G	iear				General					_	_	
		Bending				Bend		Grain			Ovalized		Pressure/Forced
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		Cracks				Broken/Damaged		nspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped.			Burrs	Πı	nstruct	ions Incomplete/	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	П	Cuffs				Contamination -		Mainte	nance		Part Moved	•	
	$\Box$	Heat Trea	at			Countersink		Mislabe	led		Positioned V	Vrong	
	П	Inspection	n Strip in	Tube		Cut Too Short		Misreac	I		Power Loss/	Surge	Other
	П	Ripples in	Bend			Drill Holes	П	Offset			-	•	
		Torque W	aves in E	xtrusion	, [	Drawing	П	Out of C	Calibration				
	$\vdash$	Turning S				Finish	П	Out of S	equence				
	П	Wave/Tw	ist in Tub	ne		Folio			Dimensions				

NCR: Yes / No

October-18-12 1:58:48 PM

Item ID: Revision ID: Item Name:	647.2011 Lower Strut			Accept	*N900040	າ1ດຕ	)* Se	etup Start Stop	ומיטו	
Start Date: Required Date: Reference:	18/10/2012	Start Qty: 12.00 'Req'd Qty: 12.00	*12* *12*		Cust Item ID: Customer:					<b>5</b> /"
Approvals:	Process Pla	ın:	Date:	Tooling:	Date:		Rı		"171	R1*
	QC:		Date:	SPC (Y/N):	Date:			Stop	*NI	R2*
Sequence ID/ Work Center II  170 *170* QC Quality Control  180 *180* Purchasing Purchasing	D	Operation Description QC8- Inspect parts - second Memo PURCHASING Memo Issue P/O:	check	Set Up/ Run Hours 0.00 0.00 0.00 0.00 ANODIZE AS PER DW	L12/12/24	# Plan Code	Accept Qty	Qty	Reject Number	Insp. Stamp
*100* Packaging Packaging		Receive & Inspect for Dama  Memo  Ensure certifica	ige & Mat'l Certs te of conformity is attack	0.00 0.00 hed				// 13/2	) 3/ <b>18</b> 5	<u> </u>

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFOR	MANCE / UP	DATE			20
											QA Closed:	Date:	¥
Vork Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
						Rework	]		Skid-tube	Crosstube	]	Water Jet	Engineering
Part	No.	-				Scrap	-		Machining	Small Fab	4	d. Eng. Coor.	Quality
NCR	No.					Use-as-is Work Order Update	1		noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
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Root					Descri	ption of work order update	l	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
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Landi	ng (	Gear	·			General							
		Bending				Bend		Grain			Ovalized		Pressure/Forced
	Г	Centre No	ot Concer	ntric to (	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorred	et 🗍	Weld
		Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved	-	
		Heat Trea	it			Countersink		Mislabe	eled		Positioned V	Vrong	_
		Inspection	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					
		Torque W	aves in E	xtrusio	n [	Drawing	L	Out of (	Calibration				
		Turning So	equence			Finish	Out of Sequence						

Outside Dimensions

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Wave/Twist in Tube

Folio

October-18-12	1:58:48 PM	· · · · · · · · · · · · · · · · · · ·										
Item ID: Revision ID: Item Name:	647.2011 Lower Strut			Accept	*N900	)040	100	)*	Setup S	tart Stop	*N:	S1* S2*
Start Date: Required Date: Reference:	18/10/2012 01/11/2012	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item Customer:		•				1 4	
Approvals:		an:	Date:	Tooling: SPC (Y/N):		oate:		1		tart Stop	*N  *N	R1* R2*
Sequence ID/ Work Center II 200 *200* QC Quality Control	)	Operation Description QC5- Inspect part comple Memo	eteness to step on W/O	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		eject lumber	Insp. Stamp
201 *201 *SprayPaint Spray Painting		<b>Memo</b> PRIME AS F CARDINAL	PER DWG 4860-50 PRIMER BATC	0.00 0.00 CH: <b>\24204</b>				14	Ø_		<b>ø</b> .	13-4-1
203 *203* QC Quality Control		QC14- Inspect Spray Pair	nt	0.00				14				045) 05/13/04-0

NCR:	: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE -												
											QA Closed:	Date	• • • • • • • • • • • • • • • • • • •
Nork Ord	er:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
						Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part I	۷o.					Scrap	]	1	Machining	Small Fab	_	d. Eng. Coor.	Quality
						Use-as-is			noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR I	Vo.		<del> </del>			Work Order Update	┛		Large Fab	Composite		Supplier	_
Root		·			Descr	iption of work order update	Τ	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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Landi		•			_	General	_	1			٦	_	
	Ш	Bending				Bend	$\vdash$	Grain		-	Ovalized	<u> </u>	Pressure/Forced
		Centre No	t Concer	tric to	o/s	BOM/Route	<u> </u>	Hardwa		<u> </u>	Over/Under	<b> </b>	Temperature/Cure
		Cracks			_	Broken/Damaged			on Incomplete	ļ	Part Incorred	—	Weld
		Crushed/0	Crimped.		<u> </u>	Burrs	L	4	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs			<u> </u>	Contamination	_	Mainte		<u>_</u>	Part Moved		
đ	4	Heat Trea	t			Countersink		Mislabe	led	L	Positioned V	Vrong	_
•	Ш	Inspection		Tube		Cut Too Short		Misread	I	<u></u>	Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					
		Torque W	aves in E	xtrusio	1 <u> </u>	Drawing		Out of 0	Calibration		•		
		Turning Se	equence			Finish		Out of S	Sequence				
		Wave/Twi	ist in Tub	e	ſ	Folio		Outside	Dimensions				

Date: \_

DQA:

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Work Ord October-18-12		803		*918	30.3*	,				Pag	ge 4
Item ID: Revision ID:	647.2011			Accept	*N900	<b>040</b> 1	1 NN*	Setup	Start	*NS1*	<u>"</u>
Item Name:	Lower Strut							,	Stop	*NS2*	k
Start Date: Required Date Reference:	18/10/2012 : 01/11/2012	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item II Customer:	D:					
Approvals:		in:	Date:	Tooling:		te:		Run	Start Stop	*NR1	*
	QC:		Date:	_ SPC (Y/N):	Da	te:			orop	*NR2	*
Sequence ID/ Work Center I	D	Operation Description Identify as per dwg & Sto	ck Location: 57/38	Set Up/ Run Hours 0.00	Tool ID		Plan According Code Qty		ject I	Reject Insp. Rumber Stamp	)
*210* Packaging Packaging		Memo	Y AS PER APICAL MPP	0.00	4 AND DEN/***				13/	5 (	7/
220		QC21- Final Inspection -		0.00	AND REV				13/4	1/109	4
*220* QC Quality Control		Memo	·	0.00			<u> </u>			mr !	
										134	-9

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE											
									QA Closed:	Date:	
Work Order	:				DISPOSITION	_		AGAINST	DEPARTMENT	/PROCESS	_
Part No	D				Rework Scrap Use-as-is			Skid-tube Crosstube  Machining Small Fab  noforming Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No	). 				Work Order Update	]		Large Fab Composite		Supplier	
Root				Descr	iption of work order update		nitial	Action	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description	Date	Verification	QC Inspector
oc/Data quip/Tooling perator flaterial etup ther roccess upplier raining napproved											
		·			F	AUL	T CATE	GORY	<u> </u>		
Landing	Gear				General						
	Cracks Crushed/ Cuffs Heat Trea Inspectio	n Strip in n Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/Unclear nance led	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
ļ	Torque W		xtrusioi	'  -	Drawing Finish			Calibration Sequence			

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

## **Picklist Print**

October-18-12 1:58:52 PM

Work Order ID: 91803

647.2011

Parent Item Name: Lower Strut

\*91803\*

\*647 2011\*

**Start Date: 18/10/2012** 

**Required Date:** 01/11/2012

**Start Qty: 12.00** 

Required Qty: 12.00

Comments:

Parent Item:

IPP REV:A NEW ISSUE 12-10-09 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.563		Purchased	No				f	106.0000	*	31.57895	,		
*M6061T6I	R0 563	*							**	8	1	15110	129

6061-T6 ROUND BAR .563

Location	Loc Qty	Loc Code	
MAT	10		
123218	10		
MAT012	96		
123294	96		

Page 1

						•					DQA:	Date:	**
NCR:	Yes	/ No				WORK ORDER NON	1-COI	NFORM	MANCE / UP	DATE			•
											QA Closed:	Date:	•
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No.  NCR No.						Rework Skid-tube Machining Use-as-is Thermoforming Large Fab		Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root					Descri	ption of work order update		nitial	Λ.	tion	Sign &		· · · · · · · · · · · · · · · · · · ·
Cause		Date	Step	Qty	· '	or Non-conformance		ief Eng		cription	Date	Verification	QC Inspector
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Operator													
Material													
Setup						,							
Other													
Process													
Supplier													
Training						•							
Unapproved											ļ.,, <u>.</u> ,		
							FAUL	T CATE	GORY				
Landir					_	General		1		<del></del>	7	·	1
		Bending		1.	-  -	Bend	<u> </u>	Grain		ļ	Ovalized	<u> </u>	Pressure/Forced
	-	Centre No	t Concen	tric to (	D/S	BOM/Route		Hardwa			Over/Under	<u> </u>	Temperature/Cure
	-	Cracks				Broken/Damaged		1	on Inçomplete	<u> </u>	Part Incorre	<del> </del>	Weld
	_	Crushed/C	crimped.		. ⊢	Burrs		į	ons Incomplete/	'Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
		Cuffs			<u> </u>	Contamination	_	Mainte			Part Moved		
	_	leat Trea	-			Countersink		Mislabe	led		Positioned V		1
	Inspection Strip in Tube			Cut Too Short Misread				Power Loss/	Surge	Other			

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

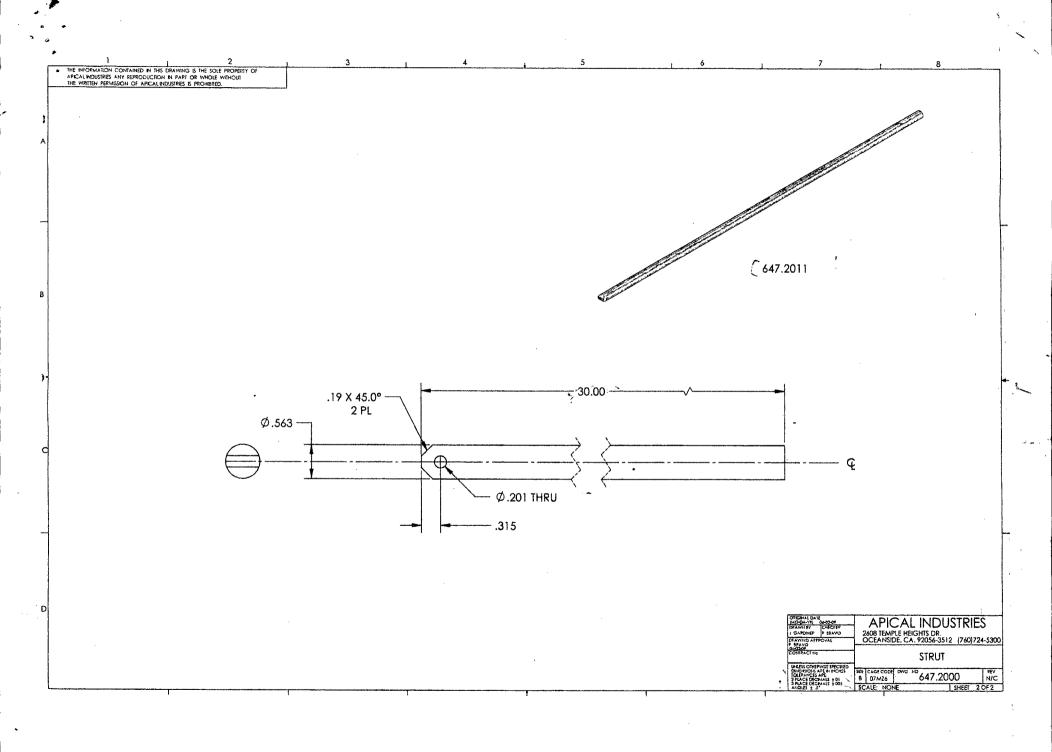
Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



DART AEROSPACE LTD	Work Order: 9/803		
Description: Lower Strut	Part Number: 6 47.2011		
Inspection Dwg: 642.2000 Rev: N/C	Page 1 of 1		

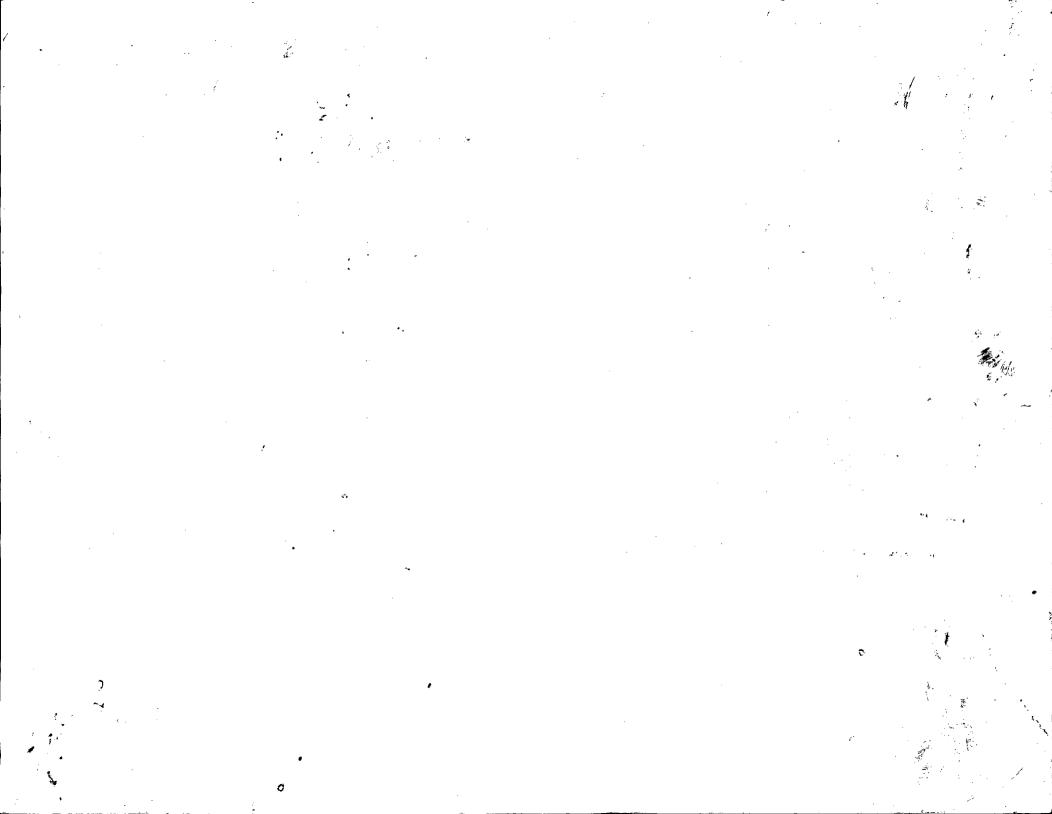
## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.563	=,005	1223			51-5	VIL
.19x450	=.010/=.5	.18 X45°				
0,201	2,005	18 X45° 6.201				/
.315	±.005	, 314				/
				4		
30.00	±.010	3000			19/1	1-12
					U	
		·				
					,	

Measured by: 13 Audited by: Preliminary Approval:

Date: 12/12/1 Date: 12/12/4 Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	





A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

## Pack List

Number: 62212

Date: 13-Feb-13

Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada

To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada

Ph: 613-632-5200

Fax: 613-632-1185

0 10 002 0	1 ax. 013-032-1165	Pr	1: 613-632-5200	Fax: 613-632-1185					
Terms		Ship Via							
Quantity	Description				· · · · · · · · · · · · · · · · · · ·				
1	Part: ASST		Rev:						
lot									
	4 PCS-647:2010 14 PCS 647:2011								
l	4 PCS 646.9910	•							
	4 PCS 647.1813	•							
	3 PCS 647.7915 8 PCS 649.4816								
	170 PCS 646.9910								
	30 PCS 646.3715 4 PCS 647.7914								
	14 PCS 646.3713								
	41 PCS 649.4813								
	4 PCS 647.1910 16 PCS 646.9710								
	HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2		•						
	Job: 20130090	PO: PO18829	Line:						
	Certificate of Confe	Armanaa							
,									
	A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.								
	ISO 9001 : 2008 REGISTERED  ATG SALES-2010 TERMS APPLY								
	DATE: /3/2//3								
	DATE. 1 JOJ 3								
	CERTIFIED SIGNATURE :								
	SERVICE SIGNATURE.								
l	RECEIVER SIGNATURE :			•					
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